

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-012200**Date Inspected:** 21-Feb-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

**Segment 8CE**

This QA Inspector performed a preliminary random visual inspection after the grit blast of the internal components of the side plate, floor beam and bottom plate of this segment. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection. For further information, please see attached pictures.

**Bay breakdown****Bay#1**

FCAW welding performed on Traveler rail at bay#1 welder 219188, One ZPMC quality control personal Yin Dong Hai and two ABF personals were present during welding.

**Bay#2 and 3**

No work performed by ZPMC Personal

**Bay#5, 6, 7 and 8**

No work performed by ZPMC Personal

**Bay#1**

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## WELDING INSPECTION REPORT

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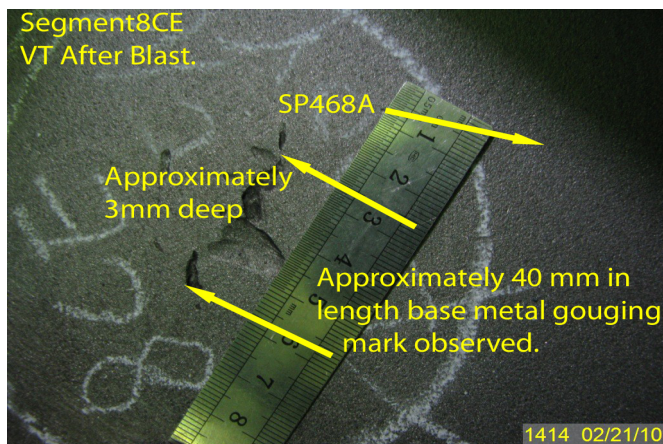
FCAW welding of weld joint 20TR1-022-005 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR1-022-007 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR1-022-003 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

FCAW welding of weld joint 20TR1-022-001 located on Traveler Rail 20TR1. Welder is identified as 219188 (1G). ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the Applicable WPS-B-T-2231-Tc-U5-F.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Patel,Hiranch	Quality Assurance Inspector
<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer

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